

# Work Order ID 73246



Page 1

Friday, August 26, 2011 10:30:21 AM

Item ID: K10003

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, D205-634-011

Start Date: 8/26/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

CL

Date: 11/6/26

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

IIN634,635

Rev F

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Create White labels only per PPP K10003

CHG 007

8/26/2011

CL 11-9-1

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

CL 11-9-1

120

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

8/26/2011

CL 11-9-1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 73246**

Friday, August 26, 2011 10:30:21 AM



Page 2

Item ID: K10003

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, D205-634-011

Start Date: 8/26/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



Packaging

Identify as per dwg &amp; Stock Location:

PK

0.00

Memo

0.00

Packaging

Rev 2

11/9/9 sl 40

140



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

11/9/13 MF 11-09-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, August 26, 2011 10:30:18 AM

Page 1

Work Order ID: 73246

Parent Item: K10003

Parent Item Name: Saddle, D205-634-011



Start Date: 8/26/2011

Required Date: 9/9/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP : I 03.01.16 Reformat: Incorporated D205-641-011 KJ/RF  
 IPP : J 06-07-25 As per DSI 9344 JLM  
 IPP : K 06.11.17 Per K10003 Rev C KJ  
 IPP : L 07.01.12 Document Record for copying bluefile rmv KJ  
 IPP Rev:M 08-08-12 now @ chg 006 (DSI 9418) DD verified by:  
 IPP N 09.01.27 DSI 9418 rev B EC verified by: DD IPP Rev:O  
 11.03.11 per dsi9536 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-51A 		Purchased	No			110	Each	163.0000	8	32			
Bolt													

Location	Loc Qty	Loc Code
ST361	163	
117514	13	
118451	100	
118628	50	

117514 13  
118451 19

AN4-6A 		Purchased	No			110	Each	1,060.000	16	64			
Bolt													

Location	Loc Qty	Loc Code
ST356	900	
117872	200	
118422	300	
118628	400	
ST358	160	
117514	160	

117514

AN4C46A 		Purchased	No			110	Each	39.0000	4	16			
BOLT													

Location	Loc Qty	Loc Code
ST360	39	
110823	39	

110823

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, August 26, 2011 10:30:18 AM

Page 2

Work Order ID: 73246

Parent Item: K10003

Parent Item Name: Saddle, D205-634-011

Start Date: 8/26/2011

Required Date: 9/9/2011

Start Qty: 4.00

Required Qty: 4.00

AN6-12A Purchased No

110 Each

55.0000

8

32

Bolt

Location

Loc Qty

Loc Code

ST342

55

118451

55

110 Each

0.0000

32

128

AN960JD416 NAS1149D0463J Purchased No

Washer

AN960JD616 NAS1149D0663J Purchased No

Washer

D2570 Manufactured No

110 Each

44.0000

24

96

Bushing

Location

Loc Qty

Loc Code

ST017

44

66933

1

67759

6

72122

37

110 Each

9.0000

1

4

D2571 Manufactured No

Saddle, Fwd Out 205

Location

Loc Qty

Loc Code

ST433

9

72340

9

Friday, August 26, 2011 10:30:18 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Friday, August 26, 2011 10:30:18 AM

Page 3

Work Order ID: 73246

Parent Item: K10003

Parent Item Name: Saddle, D205-634-011

Start Date: 8/26/2011

Required Date: 9/9/2011

Start Qty: 4.00

Required Qty: 4.00

D2572 Manufactured No

110 Each 6.0000



Saddle, Fwd In 205



4

Location

Loc Qty

Loc Code

ST433

6

71107

2

72341

4

72341

D2573 Manufactured No

110 Each 7.0000



Saddle, Aft Out 205



1

Location

Loc Qty

Loc Code

ST434

7

72190

7

72190

D2574 Manufactured No

110 Each 5.0000



Saddle, Aft In 205



1

Location

Loc Qty

Loc Code

ST434

5

72189

5

72189

D2747 Manufactured No

110 Each 82.0000



Set Screw



4

Location

Loc Qty

Loc Code

ST021

82

71163

82

71163

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, August 26, 2011 10:30:18 AM

Page 4

Work Order ID: 73246

Parent Item: K10003

Parent Item Name: Saddle, D205-634-011

Start Date: 8/26/2011

Required Date: 9/9/2011

Start Qty: 4.00

Required Qty: 4.00

D2876 Manufactured No  
Saddle Spacer

110 Each 51.0000 2 8

Location Loc Qty Loc Code

ST025 51  
70767 7  
72136 44

70767 74  
72136 14

D2877 Manufactured No  
Saddle Spacer

110 Each 53.0000 2 8

Location Loc Qty Loc Code

ST025 53  
68283 5  
72135 48

68283 30

D3405-041 Manufactured No  
Lug Assembly

110 Each 2.0000 1 4

Location Loc Qty Loc Code

ST474 2  
62227 2

70980

D3405-043 Manufactured No  
Lug Assembly

110 Each 4.0000 1 4

Location Loc Qty Loc Code

ST423 2  
65703 2  
ST478 2  
70821 2

70821

Friday, August 26, 2011 10:30:19 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, August 26, 2011 10:30:19 AM

Page 5

Work Order ID: 73246

Parent Item: K10003

Parent Item Name: Saddle, D205-634-011

Start Date: 8/26/2011

Required Date: 9/9/2011

Start Qty: 4.00

Required Qty: 4.00

D3407-041

Manufactured No

110 Each

11.0000

1

4



Tow Ring

Location

Loc Qty

Loc Code

ST

1

72145

1

ST463

10

71585

10

72145 14

71585 30

D3417-5

Manufactured No

110 Each

28.0000

2



Washer

Location

Loc Qty

Loc Code

ST053

28

71855

28

71855

D3456-1

Manufactured No

110 Each

51.0000

1



Washer

Location

Loc Qty

Loc Code

FG

7

25701

7

ST054

44

66848

3

71165

41

71665

D3533-1

Manufactured No

110 Each

12.0000

2



Set Screw

Location

Loc Qty

Loc Code

ST066

12

67583

12

67583

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, August 26, 2011 10:30:19 AM

Page 6

Work Order ID: 73246

Parent Item: K10003

Parent Item Name: Saddle, D205-634-011

Start Date: 8/26/2011

Required Date: 9/9/2011

Start Qty: 4.00

Required Qty: 4.00

MS21042L4

Purchased

No

110

Each

4,137.000

24

96



Nut

Location

Loc Qty

Loc Code

ST300

4137

117441

51

117601

637

117885

1449

118451

2000

117880

MS21043-4

Purchased

No

110

Each

876.0000

5

20



Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

836

117793

480

118378

356

1118378

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



## 5.0 PARTS LIST

Item	634 -011	634 -015	634 -041	634 -045	641 -011	Part Number	Description
	X					D205-634-011	SKIDTUBE INSTALLATION (STANDARD)
		X				D205-634-015	SKIDTUBE INSTALLATION (MODIFIED)
1			X			D205-634-041	SKIDTUBE
		1		X		D205-634-045	SKIDTUBE
1	1	1			X	D205-641-011	GROUND HANDLING KIT
1			1			D2580-041	205 SKIDTUBE ASSEMBLY (STANDARD)
1				1		D2580-045	205 SKIDTUBE ASSEMBLY (MODIFIED)
2A			16	16		D2594-1	* PLUG
2B			16	16		D2594-3	* O-RING
3			1	1		D2855	* AFT CAP
4			2	2		AN3-5A	* BOLT
5			2	2		NAS1149D0332J	* WASHER (AN960JD10L)
6A			1	1		D3564-9	* WEARSHOE (REPLACES D2577-1)
6B			1	1		D3566-1	* GASKET
7A			1	1		D3564-11	* WEARSHOE (REPLACES D2577-3)
7B			1	1		D3566-1	* GASKET
8A			1	1		D3564-5	* WEARSHOE (REPLACES D2577-5)
8B			1	1		D3566-5	* GASKET
9A			1	1		D3564-13	* WEARSHOE
9B			1	1		D3566-13	* GASKET
10			50	50		AN3C4A	* BOLT (REPLACES AN3-4A)
11			50	50		NAS1149C0332R	* WASHER (AN960C10L)
12			50	50		ALS4-1032-130	* INSERT
13			2	2		ALS4-1032-225	* INSERT
20	1	1				D2571	SADDLE, FWD OUTSIDE
21	1	1				D2572	SADDLE, FWD INSIDE
22	1	1				D2573	SADDLE, AFT OUTSIDE
23	1	1				D2574	SADDLE, AFT INSIDE
24	8	8				AN4-51A	BOLT
25	16	16				D2570	BUSHINGS
26	8	8				MS21042L4	* NUT (OR MS21042-4)
27	8	8				AN6-12A	BOLT
28	8	8				NAS1149D0668J	WASHER (AN960JD616)
29	16	16				AN4-6A	BOLT
30	32	32				NAS1149D0463J	WASHER (AN960JD416)
31	16	16				MS21042L4	NUT (OR MS21042-4)
32	4	4				D2747	SET SCREW
33	2	2				D3533-1	SET SCREW
40	1	1				D3407-041	TOW RING (REPLACES D2968-041)
41	1	1				D3456-1	WASHER
43	1	1				MS21043-4	NUT
44	2	2				D3417-5	WASHER
50					1	D3405-041	LUG ASSEMBLY (REPLACES D2736-1)
51					1	D3405-043	LUG ASSEMBLY (REPLACES D2736-3)
52					4	AN4C46A	BOLT
53					8	D2570	BUSHING
54					4	MS21043-4	NUT (OR MS21042-4)
60	2	2				D2876	SADDLE SPACER
61	2	2				D2877	SADDLE SPACER

\*DENOTES THAT PART IS INCLUDED WITH D2580-041/-045 ASSEMBLY ABOVE

• COPYRIGHT © 1996 BY DART AEROSPACE LTD •  
 THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED  
 OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: G

Date: 11.06.24